Work Orde June-12-13 9:25		3016	1	*103				Page 1			
Item ID: Revision ID:	D2022-101			Accept	*N9000	140	100)* s	etup Star	IV.	S1*
Item Name:	Spacer	/ 1	o. 0/1						Stop	′ *N:	S2*
Start Date: Required Date:	6/10/13 6/11/13	Start Qty: 40.00 Req'd Qty; 40.00	′ *4∩* *40*		Cust Item ID: Customer:						
Reference:		·			<u>.</u>			_	C .		
Approvals:		an: MF.	Date: 13-6-1		Date		·	R	un Star Sto _l	. " \]	R1*
	QC:		Date:	_ SPC (Y/N):	Date);				*N	R2*
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours	Tool ID		Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr							-		
D2022	rev	97.01.14									
100				0.00							
100 Hardinge Hardinge CNC Lathe	e Small	Memo Note:.257" 1-Turn as p FOLIO REV DWG REV 2-Deburr as	er folio FA206 & dwg V: :	0.00 OAA	13/06/22	. •		6	\$		
		2-Debuil as	тецинец			•					•
*110 *110*		QC2- Inspect parts off n	nachine FAI/FAIB	0.00 CAA	13/06/22	,		60	Ø		,
QC Quality Control		Memo		9.00 g.8	, , , - \(\alpha\) = \(\alpha\)	-					

DQA:			Date:										[™] ⊃∧ DT
						WORK ORDER NON-	-CC	ONFO	RMANCE / U	PDATE			AEROSPĀCE
QA Closed:			Date:							V	Vork Order u	pdate only	,
Work Orde	ar.					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
WOIR OIG	- '			-	_	Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab			d. Eng. Coor.	Quality
	•				_	Use-as-is			Thermoforming Finishing			re/Packaging	Other
NCR N	10.					Suspected Unapproved Large Fab				Composite			
												_	
Root					Desci	ription of work order update	1	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	n QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process						• .							
Supplier							'						
Training													
Transport Unapproved										•			
опарргочец			<u> </u>			·	FΔI	HT CA	TEGORY		<u>.</u>	<u> </u>	<u> </u>
Landi	ng (Gear				General		our ca	i cooki	-		· · · · · · · · · · · · · · · · · · ·	
20.101		Bending				Bend		Folio/F	Program	Γ	Outside Dim	ensions [Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	-	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are	<u> </u>	Part Incorre	}-	Temperature/Cure
	-	l	nk/Ripple	/Wave		Burrs		ł	ion Incomplete/U	ngualified	Part Lost/M	issing	Weld
	Crimp/Kink/Ripple/Wave Cuffs				Contamination		1 '	tions Incomplete/	· -	Part Moved	· · ·	Wrong Stock Pulled	
	· Crushing				Countersink		1	ned/off center		Positioned V	_		
Heat Treat				Cut Too Short		Mislabe	eled	T	Power Loss/	Surge	Other		
Inspection Strip in Tube				Drawing		Misread	d	_					
	Marks/Chatter				Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration				
	Wave/Twist in Tube					Fit/Function		Out of Sequence					

Work Order II June-12-13 9:25:17 A				Page 2					
Item ID: D202 Revision ID: Item Name: Space	2-101 r		Accept	*N900040	1100)* s	Setup Star Stop	ı V.	S1* S2*
Start Date: 6/10/ Required Date: 6/11/ Reference:		*40* *40*		Cust Item ID: Customer:	_	ī	Run Star	t _L_R_11	- 4 +
• •	cess Plan:	Date:	Tooling: SPC (Y/N):	Date:		,	Stop	!/	R1* R2*
Sequence ID/ Work Center ID 120 *120* QC Quality Control	Operation Description QC8- Inspect parts - seco	nd check	Set Up/ Run Hours 0.00	Tool ID Tool #	Flan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp AS 13 9-89
*130 *130* Packaging Packaging	Identify as per dwg & Sto	ock Location:	0.00			lov	.		13-6
140 *140* QC Quality Control	QC21- Final Inspection - Memo	Work Order Release .	0.00				13/4	,/25 [b.06	Sh.

DQA:		_ Date:			– · · · · · · · · · · · · · · · · · · ·									
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UI		Vork Order uj	odate only	AEROSPÂCE		
					DISPOSITION					EPARTMENT	· · · · · · · · · · · · · · · · · · ·			
Work Orde	er:				·	,			_	-	Water Jet	_		
				i	Rework			Skid-tube	Crosstube		Engineering			
Part N	NO				Scrap			Machining	Small Fab	_	d. Eng. Coor.	Quality		
NCR N	do.				Use-as-is Suspected Unapproved		merr	noforming Large Fab	Finishing Composite		re/Packaging Supplier	Other		
INCK I	.				Suspected Onapproved			carge rab	Composite		Supplier			
Root				Desc	ription of work order update	1	nitial	Act	ion	Sign &				
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector		
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator														
Offset/Setup														
Process														
Supplier														
Training														
Transport														
Unapproved														
			· · · · · · · · · · · · · · · · · · ·			FA	ULT CA	TEGORY						
Landi	ng Gear			,	General				_		_	_		
	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced		
	Centre N	lot Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up		
	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorre	ct	Temperature/Cure		
	Crimp/K	ink/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	nqualified	Part Lost/M	issing	Weld		
	Cuffs				Contamination		Instruct	tions Incomplete/U	Jnclear	Part Moved		Wrong Stock Pulled		
	Crushing	Ţ.		L	Countersink		Misalig	ned/off center		Positioned V	Vrong	<u> </u>		
	Heat Tre	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other		
	Inspection	on Strip in	Tube	L	Drawing		Misread	t						
	Marks/C	hatter		L	Drill Holes		Off-set							
	Turning	Sequence			Finish		Out of	Calibration						
	Wave/Twist in Tube				Fit/Function		Out of S	Sequence						

Picklist Print

June-12-13 9:25:17 AM

Work Order ID:

103016

Parent Item:

D2022-101

Parent Item Name:

Spacer

Start Date: 6/10/13

Required Date: 6/11/13

Start Qty: 40.00

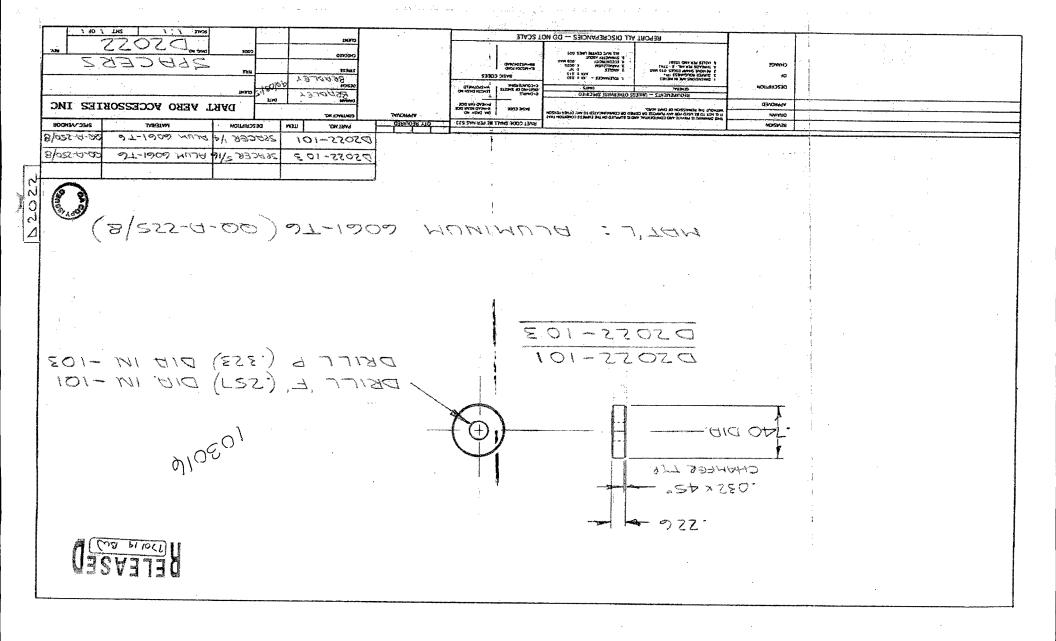
Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	80.7810	0.03	1.2			
6061-T6 Round Bar .750"												# · · · · · · · · · · · · · · · · · · ·	
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT		9 80.781							
				125	552	80.781			10	4 4 F	K 13/0	×4/23	

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DQA:			Date:			_										
						WORK ORDER NON	-C(ONFO	RMANCE / UPDATE			i		AEROSPÂCE		
QA Closed:			Date:					,		Wo	rk Order up	date only				
Work Orde	or.	•				DISPOSITION			AGAINST	DEP	ARTMENT	PROCESS				
Work Orac	-	**				Rework]		Skid-tube Crosstube			Water Jet		Engineering		
Part N	No.					Scrap			Machining Small Fab	_	Pro	d. Eng. Coor.	\dashv	Quality		
	-					Use-as-is	1		noforming Finishing	$\boldsymbol{\vdash}$		e/Packaging		Other		
NCR N	No					Suspected Unapproved]		Large Fab Composite			Supplier				
Root					Desc	ription of work order update		Initial	Action		Sign &					
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verificatio	n	QC Inspector		
Design							П									
Doc/Data																
Equip/Tooling	Ш										,					
Handling/Pre	Ш															
Material	Ш												l			
Operator	Ш															
Offset/Setup	Ш															
Process	Ш															
Supplier	Ш															
Training	Ш															
Transport													-			
Unapproved	LL						<u> </u>			L						
						· · · · · · · · · · · · · · · · · · ·	FA	ULT CA	TEGORY							
Landi	_					General	_	1								
	\vdash	Bending			-	Bend		4	Program	-	Outside Dim		-	Pressure/Forced		
٠	$\boldsymbol{\vdash}$	Centre No	ot Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain			Over/Under		-	Set-up		
:	-	Cracks			-	Broken/Damage/Defect	<u> </u>	Hardwa		\vdash	Part Incorrec			Temperature/Cure		
,	-	Crimp/Kir	nk/Ripple	/Wave	-	Burrs	<u> </u>	•	ion Incomplete/Unqualified	\vdash	Part Lost/Mi	-	-	Weld		
	Cuffs			<u> </u>	Contamination	_	4	tions Incomplete/Unclear	\vdash	Part Moved			Wrong Stock Pulled			
	\vdash	Crushing			_	Countersink	 	₹ 7	gned/off center	-	Positioned W					
	-	Heat Trea			_	Cut Too Short	<u> </u>	Mislabe			Power Loss/S	Surge		Other		
	-	Inspection		Tube	<u> </u>	Drawing	<u> </u>	Misrea		_				·		
	\vdash	Marks/Ch			_	Drill Holes	<u> </u>	Off-set		_			<u></u>			
	-	Turning S			<u> </u>	Finish	L	4	Calibration	_				· - - · · · · · · · · · · · · · · · · · ·		
	Wave/Twist in Tube			oe -		Fit/Function	Out of Sequence									



DQA:			Date:												TOAC
		•				WORK ORDER NON	-CC	ONFO	RMANCE / L	UPDATE					AEROSPACE
QA Closed:			Date:								Wo	ork Order up	odate only		
Work Orde	er:					DISPOSITION			· · · · · · · · · · · · · · · · · · ·	AGAINST	DE	PARTMENT,	/PROCESS		
	•				_	Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part N	No.					Scrap	1 1	Machining Small Fab			Prod. Eng. Coor.			┢	Quality
	•					Use-as-is			noforming	Finishing			re/Packaging		Other
NCR 1	No.					Suspected Unapproved						Supplier			
							_							•	
Root					Desci	ription of work order update	1	nitial	A	ction		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription		Date	Verificatio	n	QC Inspector
Design	Ш														
Doc/Data															
Equip/Tooling	Щ														
Handling/Pre			•	i											
Material					:										
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Offset/Setup	Ш						1								
Process			į.												·
Supplier											,				
Training							1								
Transport							ł								
Unapproved							i								
							FAL	ULT CAT	TEGORY						
Landi	$\overline{}$				_	General		1 .		,		I			1
	\vdash	Bending			<u> </u>	Bend	Щ	i	rogram		_	Outside Dim		_	Pressure/Forced
	Н	Centre No	ot Concer	ntric		BOM/Route	Щ	Grain			-	Over/Under		_	Set-up
	-	Cracks				Broken/Damage/Defect	Ш	Hardwa			-	Part Incorred		_	Temperature/Cure
	Crimp/Kink/Ripple/Wave			/Wave	_	Burrs	Ш	1	ion Incomplete/l	· ·		Part Lost/Mi	•	<u> </u>	Weld
	Cuffs			_	Contamination	Ш	1	ions Incomplete			Part Moved		L	Wrong Stock Pulled	
Crushing			_ 	Countersink		-	ned/off center	r	_	Positioned V	-		,		
Heat Treat				Cut Too Short		Mislabe		İ		Power Loss/	Surge	L	Other		
Inspection Strip in Tube			_	Drawing	Ш	Misread									
Marks/Chatter				Drill Holes	Ш	Off-set			,						
Turning Sequence					Finish		1	Calibration							
C X.	Wave/Twist in Tube					Fit/Function		Out of Sequence							

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

DART AEROSPACE LTD	Work Order:	103016
Description: Spacer	Part Number:	D2022-101
Inspection Dwg: D2022 Rev: -		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST													
)	First Art	icle	Prot	otype								
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	C	comments						
0.226	+/-0.010	. 227	7		F4-04	Va	n .						
0.032 x 45°	+/-0.010	-032 x45°	7		l,	4							
0.740	+/-0.010	.440)	_	41	ζ.							
Ø0.257	+0.005/-0.000	. 257	7		h	4							
			-										
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			1										
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	PS AA		13	<u> </u>									
Measured by:	3-8°	Audited by:	13 9-89		Prototype App		N/A						
Date:	13/06/22	Date:	13-6-2	23		Date:	N/A						

Rev	Date	Change	Revised by	Approve/d
Α	04.10.05	New Issue	KJ/JLM	all
				—— }~~/

DQA:			Date:										TART
						WORK ORDER NON	-C(ONFO	RMANCE / UF	PDATE			AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
	-				_	Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.					Scrap	1	Machining Small Fab			Pro	d. Eng. Coor.	Quality
						Use-as-is		Therr	moforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo					Suspected Unapproved]		Large Fab	Composite	_	Supplier	
Root					Desci	ription of work order update		nitial	Acti	ion	Sign &		
Cause	_	Date	Step	Qty		or non-conformance	Ch	iief Eng	Descri	iption	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre	_												
Material	_												
Operator			(*)										
Offset/Setup	-												
Process	\dashv										*		
Supplier [*] Training	\dashv									,			
Transport										,			
Unapproved	_										,		·
оперриота ј		·····	1		L		FAL	ULT CAT	TEGORY		I		
Landi	ng G	ear				General							
		Bending				Bend		Folio/F	rogram	Г	Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain	J		Over/Under	—	Set-up
		Cracks				Broken/Damage/Defect	П	Hardwa	ire T		Part Incorred	 	Temperature/Cure
	Crimp/Kink/Ripple/Wave				Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	ssing	Weld	
	Cuffs				Contamination		Instruct	ions Incomplete/U	nclear	Part Moved	Γ.	. Wrong Stock Pulled	
	Crushing				Countersink		Misalig	ned/off center		Positioned W		_	
Heat Treat				Cut Too Short		Mislabe	eled		Power Loss/:	Surge	Other		
Inspection Strip in Tube			Drawing		Misread	1							
·		Marks/Ch	atter			Drill Holes		Off-set	٠,٠				
		Turning S	equence			Finish		Out of 0	Calibration				
Wave/Twist in Tube					Fit/Function	Out of Sequence 2.							